

Date: Wednesday, 3/7/2007 8:38:04 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	FITTING	
Job Number	31031		Part Number	D2249041	
Estimate Number	10844		Drawing Number	D2249 REV. E	
P.O. Number	N/A		Project Number	N/A	
This Issue	3/7/2007	S.O. No.	N/A	Drawing Revision	E
Prsht Rev.	NC	Type	SMALL /MED FAB	Material	N/A
First Issue	N/A			Due Date	4/10/2007
Previous Run	N/A			Qty:	5
Written By			Um:	Each	
Checked & Approved By	KJ 07.03.07				
Comment	Est: D05.02.04 Added Step 9 KJ/RF				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	31031A	LUG		
		Comment: Sub-Component LUG D2249-1 B 31031A	FC 07/03/22	(10)
2.0	31031B	LUG		
		Comment: Sub-Component LUG D2249-3 B 31031B	FC 07/03/22	(5)
3.0	31031C	GUSSET		
		Comment: Sub-Component GUSSET D2249-5 B 22498	FC 07/03/22	(10)
4.0	D22491	Lug		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Lug Pick: Qty Part Number Description Batch	FC 07/03/22	(10)
5.0	D22493	Base Plate		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Base Plate Pick: Qty Part Number Description Batch	FC 07/03/22	(6)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/03/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 8:38:04 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 31031

Part Number: D2249041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D22495 Gusset



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Gusset

(2) D2249-5 blanks per (1) D2249-041

Pick:

Qty	Part Number	Description	Batch
2	D2249-5	Gusset	1132249811

FC 07/03/22

(10)

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D2249 and QSI 004

FC 07/03/22

(5)

8.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

M 07/03/23

(5)

9.0 POWDER COATING POWDER COATING



M 103706

(5x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

m-l 07/03/26

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

1/7/3/28

(5)

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

1/7/3/28

(5)

12.0 QC21 FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

1/7/3/29

Job Completion



1/7/3/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

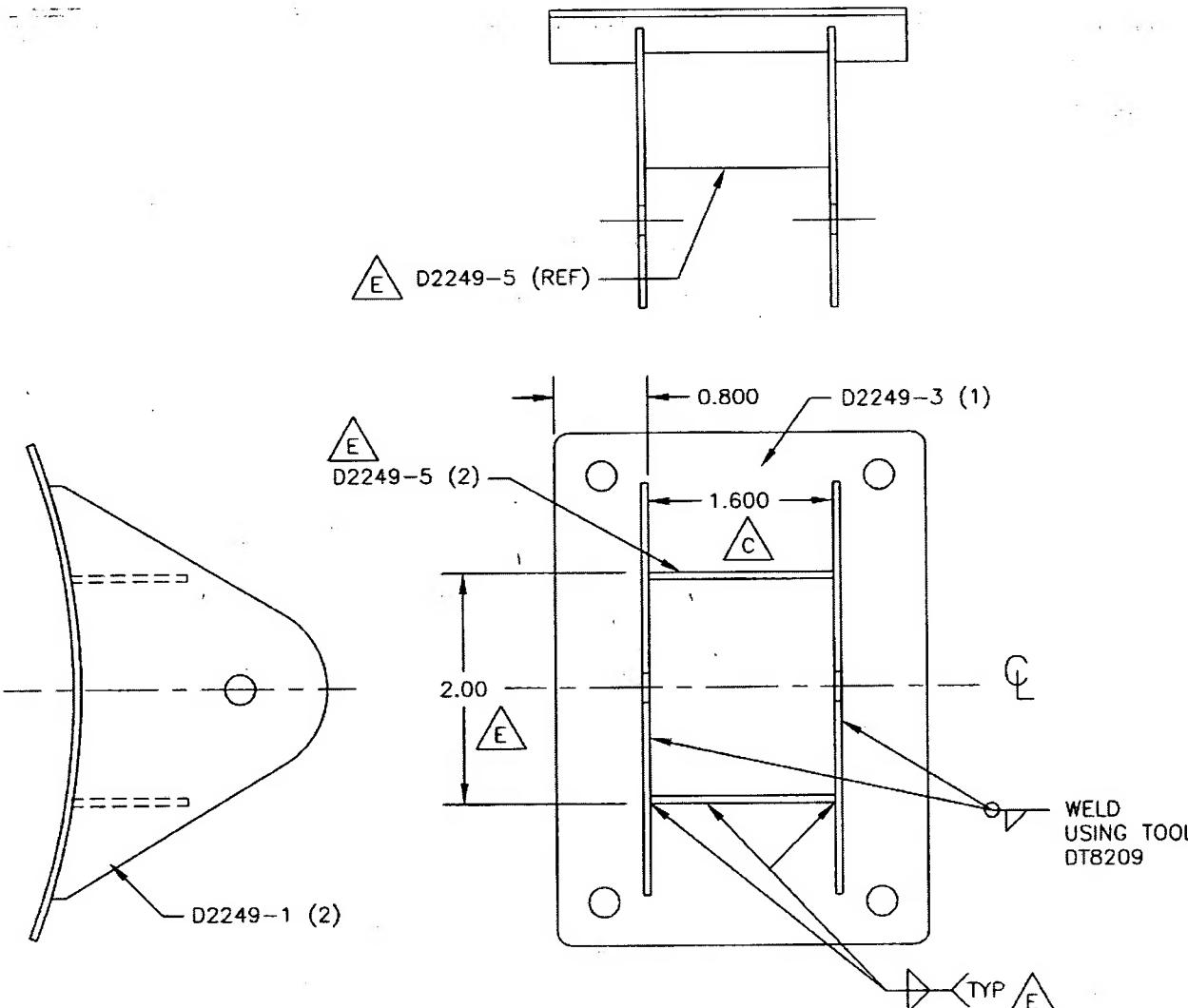
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
99.10.12
KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	REV. E
KE	W	DRAWING NO.
		D2249
DATE		SHEET 1 OF 4
99.09.20		
A	99.06.20	NEW ISSUE
B	95.11.30	DIMENSION CHANGE
C	95.12.14	DIMENSION CHANGE
D	98.04.30	0.261 WAS 0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS
E	99.09.20	ADDED GUSSET

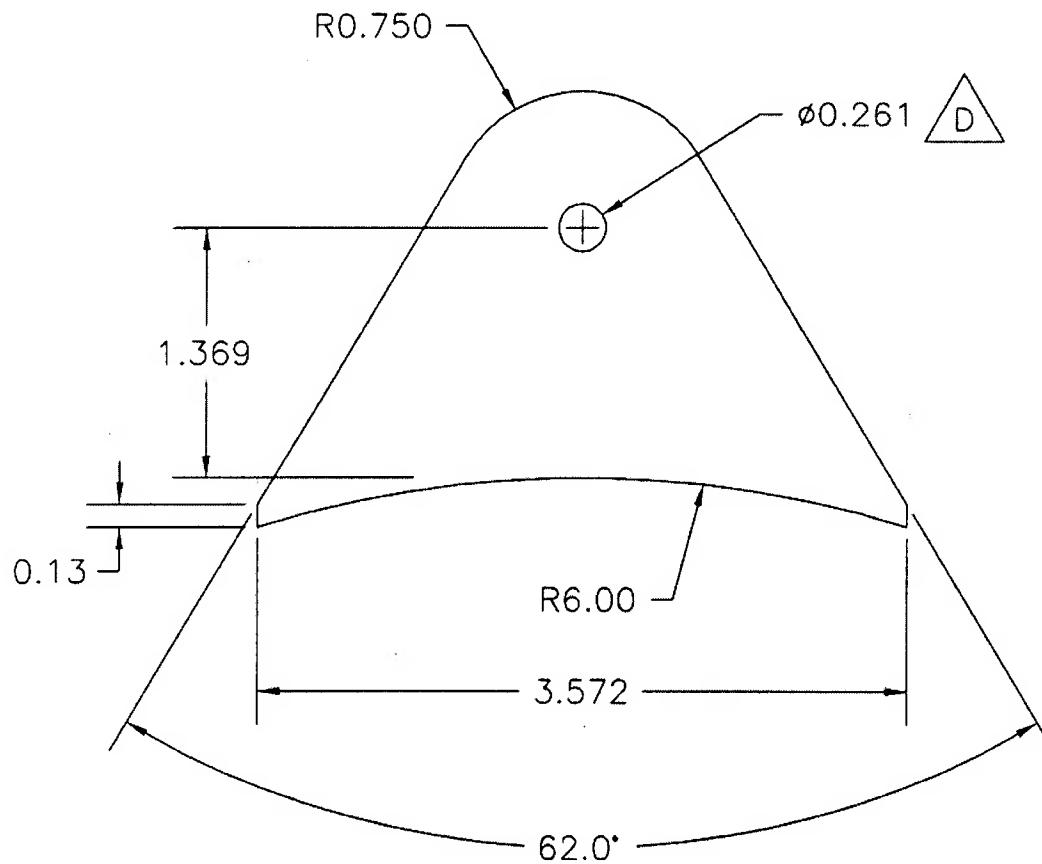
D2249-041 ASSEMBLY

MATERIAL: AISI 304/316 SS, 0.063 THICK
 WELD PER DART QSI 004
 FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 ALL DIMENSIONS ARE IN INCHES
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

DART

COPY ISSUED

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CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249	REV. E SHEET 2 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED
99.10.12 KED2249-1 LUG

MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

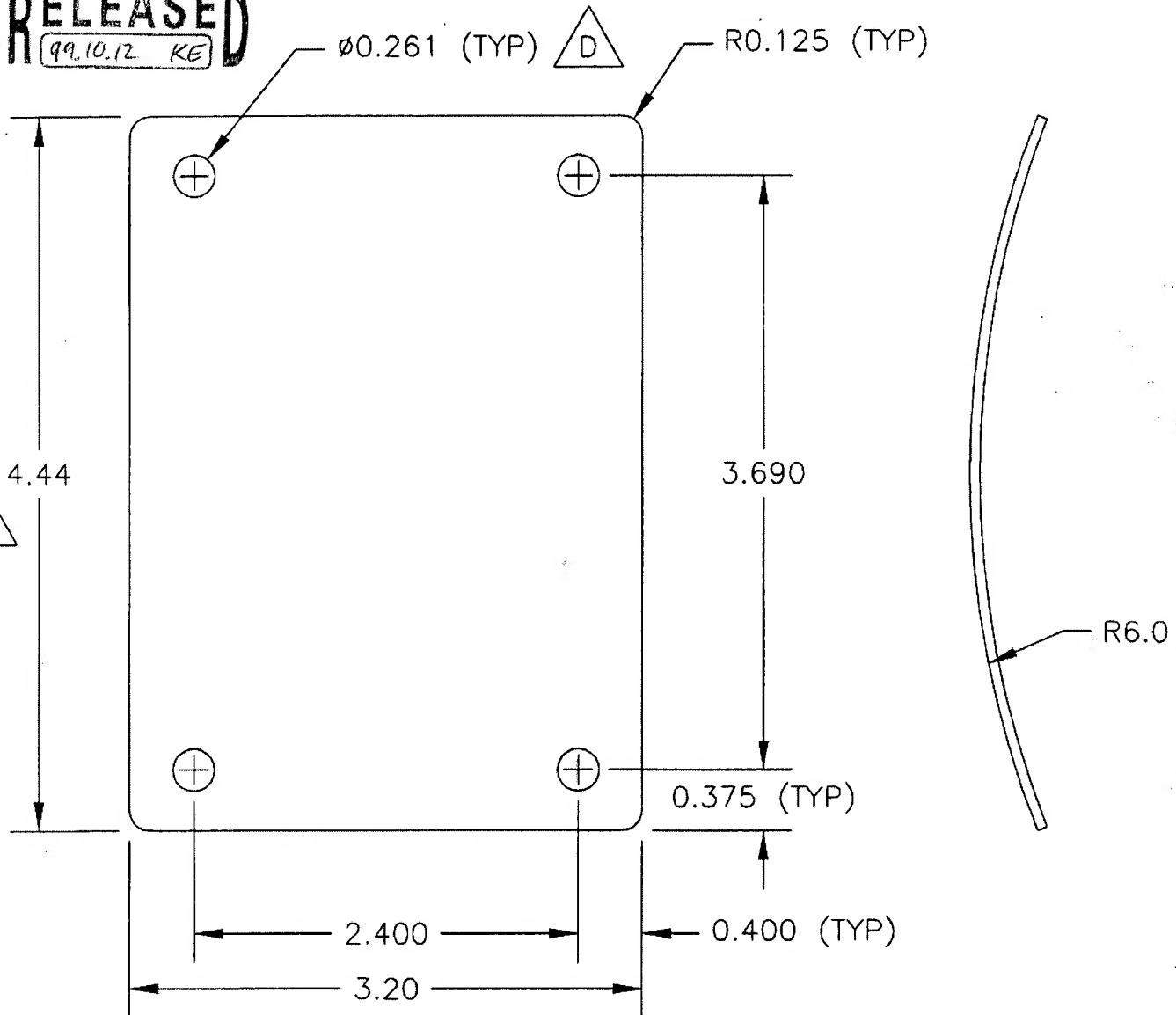
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WORK ORDER
NO. 31031



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CHECKED <i>RE</i>	APPROVED <i>W</i>	DRAWING NO. D2249	REV. E	SHEET 3 OF 4
DATE 99.09.20	TITLE FITTING		SCALE 1:1	

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99.10.12 KE

99.10.12 KE



FLAT PATTERN

D2249-3 BASE PLATE

BEND DETAIL

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MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

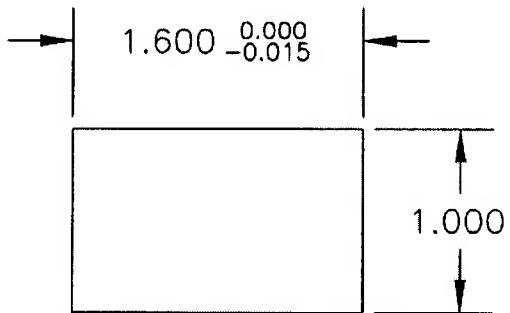
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TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DATA COPY ISSUE DEPT

DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED MM	DRAWING NO. D2249 REV. E SHEET 4 OF 4
DATE 99.09.20	TITLE FITTING	SCALE 1:1

RELEASED
99.10.12 KE



D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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